

**Work Order ID 158810****\*158810\***

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Friday, March 31, 2017 7:15:37 PM

Item ID: D4004-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Top Strap Attachment Bracket  
Start Date: 4/4/2017 Start Qty: 3.00 **\*3\*** Cust Item ID:  
Required Date: 4/6/2017 Req'd Qty: 3.00 **\*3\*** Customer:  
Reference: SCHEDULED  
Approvals: Process Plan: DAS 21 9-89 Date: MAR 30 2017 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp       |
|--------------------------------|------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------|
| Draw Nbr                       | Revision Nbr                                                           |                      |         |        |              |               |               |                  |                      |
| D4004                          | B                                                                      |                      |         |        |              |               |               |                  |                      |
| 100                            | BAND SAW                                                               | 0.00                 |         |        |              | 3             | Ø             |                  | DAS 32 9-89 17-04-04 |
| <b>*100*</b>                   |                                                                        |                      |         |        |              |               |               |                  |                      |
| Bandsaw                        | Memo                                                                   | 0.80                 |         |        |              |               |               |                  |                      |
| Jeaspa Bandsaw                 | 1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004   |                      |         |        |              |               |               |                  |                      |
|                                | Ensure cut is started at correct place per dwg                         |                      |         |        |              |               |               |                  |                      |
|                                | Batch: <u>M/31 9/3</u>                                                 |                      |         |        |              |               |               |                  |                      |
|                                | 2-Deburr                                                               |                      |         |        |              |               |               |                  |                      |
| 105                            |                                                                        | 0.00                 |         |        |              | 3             | Ø             | 17-4-5           | DAS 19 9-89          |
| <b>*105*</b>                   |                                                                        |                      |         |        |              |               |               |                  |                      |
| Small Fab                      | Memo                                                                   | 0.69                 |         |        |              |               |               |                  |                      |
| Small Fab                      | Drill and c/sink holes as per dwg and trim part to length as required. |                      |         |        |              |               |               |                  |                      |

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**\*NS1\***

Stop \*NS2\*

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

3

APR 05 2017

x3

2017/04/05  
BEB.

3

38

APR 05 2017

**Work Order ID 158810**

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Start Date: 4/4/2017 Start Qty: 3.00 **\*3\*** Cust Item ID:  
Required Date: 4/6/2017 Req'd Qty: 3.00 **\*3\*** Customer:  
Reference: SCHEDULED

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number  | Insp.<br>Stamp    |
|--------------------------------|-----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|-------------------|-------------------|
| 140                            | Identify as per dwg & Stock Location: <u>8A-070</u> | 0.00                 |         |        |              |               |               |                   |                   |
| <b>*140*</b>                   |                                                     |                      |         |        |              |               |               |                   |                   |
| Packaging                      | Memo                                                | 0.03                 |         |        |              | 3x            |               | DAS<br>26<br>9-89 | APR 05 2017       |
| Packaging                      |                                                     |                      |         |        |              |               |               |                   |                   |
| 150                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                   |                   |
| <b>*150*</b>                   |                                                     |                      |         |        |              |               |               |                   |                   |
| QC                             | Memo                                                | 0.30                 |         |        |              |               |               |                   | 17/4/10 <i>JA</i> |
| Quality Control                |                                                     |                      |         |        |              |               |               |                   |                   |

DAS  
21  
9-89  
APR 06 2017

# Picklist Print

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Work Order ID: 158810

**\*158810\***

Parent Item: D4004-11

**\*D4004-11\***

Parent Item Name: Top Strap Attachment Bracket

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD IPP Rev:B  
10.05.17 as per ECN10-562 DD verf:EC IPP Rev:C 12.03.07  
as per dwg rev.b DD verf: EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status           |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|------------------|
| D3033-144                       |                        | Manufactured  | No          |                     |                  | 100             | f                  | 386.8550       | 0.41        | 1.294737     |               |                |                  |
| <b>*D3033-144*</b>              |                        |               |             |                     |                  |                 |                    |                | <b>**</b>   |              |               | 17-04-04       | DAS<br>32<br>989 |
| Seat Track (\$ per foot)        |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |                  |

Location

Loc Qty

Loc Code

ST479a

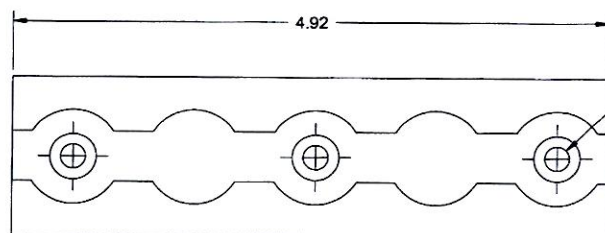
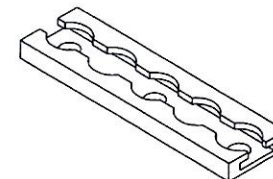
386.855

131913

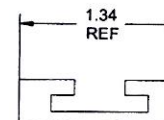
386.855

1.492'

| DART AEROSPACE<br>PART NUMBER | JOHN CAMERON AVIATION<br>PART NUMBER |
|-------------------------------|--------------------------------------|
| D4004-11                      | JCA-M47-2-11                         |



DRILL  $\varnothing 0.204$  (#6 DRILL)  
CONCENTRIC WITH SEAT TRACK  
CSK  $\varnothing 0.385 \times 100^\circ$   
3 PL



# **D4004-11 TOP STRAP ATTACH BRACKET**

RELEASED  
2012-03-02

## **NOTES:**

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144  
OR BROWNLIN P/N 20276-144-0-0  
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

|            |           |                                                                                                                                                                                                                                                                               |                |
|------------|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | <i>BC</i> | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                     |                |
| DRAWN      | <i>BC</i> | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                   |                |
| CHECKED    | <i>BC</i> | DRAWING NO.                                                                                                                                                                                                                                                                   | REV. B         |
| MFG. APPR. | <i>BC</i> | <b>D4004</b>                                                                                                                                                                                                                                                                  | SHEET 11 OF 11 |
| APPROVED   | <i>BC</i> | TITLE                                                                                                                                                                                                                                                                         | SCALE          |
| DE APPR.   | <i>BC</i> | <b>SIDE RESTRAINT</b>                                                                                                                                                                                                                                                         | NTS            |
| DATE       | 12.02.27  | COPYRIGHT © 2010 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD |                |



